

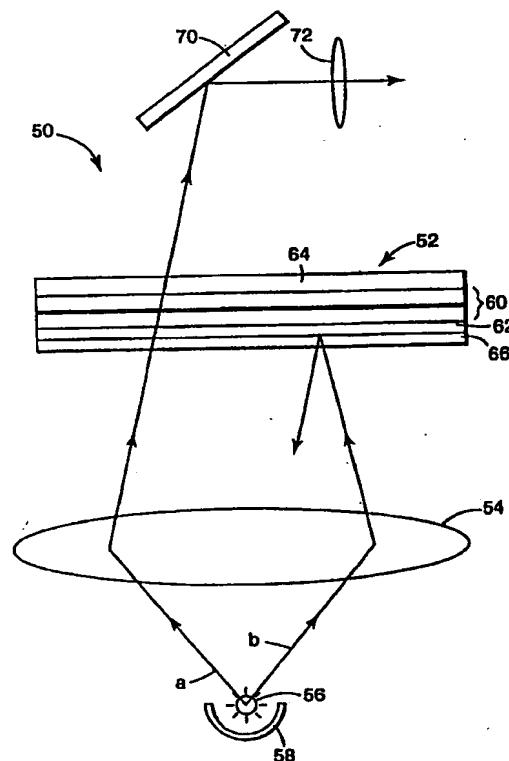
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(54) Title: LIQUID CRYSTAL DISPLAY PROJECTION SYSTEM USING MULTILAYER OPTICAL FILM POLARIZERS**(57) Abstract**

A liquid crystal display (LCD) projection system (50) including a projection panel (52), a light source (56), and a reflector (58). The projection panel includes an LCD (60) and a polarizer (64) on one side of the LCD and a reflective polarizer (62) on the other side. The reflective polarizer is a multilayer stack of pairs (44) of adjacent material layers (41, 43). Each of the layer pairs exhibits a refractive index difference between the adjacent layers in a first direction in the plane of the reflective polarizer and exhibits essentially no refractive index difference between adjacent layers in a second direction in the plane of the reflective polarizer and orthogonal to the first direction. A quarter-wave plate (66) is secured to the reflective polarizer. Light rays from the light source either pass through the reflective polarizer and on to the LCD, or are reflected back toward the light source, depending on their polarization. Light which is reflected by the reflective polarizer is reflected by the reflector back toward the LCD again. The use of the quarter-wave plate and the reflector help to recycle what would typically be regarded as wasted light, while at the same time reducing heat build-up within the LCD.



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LIQUID CRYSTAL DISPLAY PROJECTION SYSTEM USING MULTILAYER OPTICAL FILM POLARIZERS

Field of the Invention

5 The present invention relates generally to liquid crystal display projection systems and, more specifically, to such systems which incorporate multilayer optical film polarizers.

Background of the Invention

10 Liquid crystal display (LCD) projection systems offer the advantages of large image areas, compactness, ease of setup, light weight, and low cost compared with competing technologies. An LCD is comprised of thousands of small picture elements, or "pixels", which are either "on", "off", or "partially on". An image is displayed by the LCD by the appropriate manipulation, usually by applying an electric field, on the
15 individual pixels. In the case of a twisted nematic (TN) LCD, if a particular pixel is "on", then the phase, and thus the polarization, of a linearly polarized light ray will remain unchanged as it passes through the pixel. However, if the pixel is "off", then the light ray will be rotated, i.e., its phase will be modulated so that its polarization angle is changed by 90 degrees. If the pixel is "partially on", then the light ray will be rotated by
20 less than 90 degrees. An "on" pixel can be designated to represent either black or white. If the "on" pixel is designated as black, then the "off" pixel is designated as white, and vice versa. A "partially on" pixel represents a shade of gray. Polarizers are then provided on the LCD so that the polarization state of the light passing through the pixel is converted into the appropriate amount of transmission (black, white, or gray).

25 In the case of a super twisted nematic (STN) LCD, the optical effect arises from birefringence effects so that "on", "off", and "partially on" pixels each have a characteristic birefringence color. If the "blue mode" is used, the "off" pixel will have a blue color while the "on" pixel will be cream colored. If the "yellow mode" is used, the "off" pixel will be yellow and the "on" pixel will be blue-gray. A film may be added
30 between the STN LCD and one of its polarizers to neutralize the color of the display, i.e., to convert the color display to a black and white display.

Current LCD projection systems typically employ forced air or liquid cooling to protect the temperature sensitive liquid crystal material. Even when using "hot" or "cold" mirrors to substantially remove the infrared component from the illumination, the approximately 55-60% of the visible light absorbed by the first of two conventional dichroic polarizer heats the LCD laminated thereto. In many LCD projectors in which the lamp, LCD, electronics, and projection optics are incorporated into one compact unit, the first polarizer is not laminated to the LCD to reduce conductive heating of the LCD, but the polarizer itself must still be cooled. Furthermore, all LCD projection systems suffer from low light utilization (color LCDs being typically 3-5% transmissive), thus usually necessitating brighter lamps to deliver good screen illumination. However, brighter lamps not only increase cost and power consumption, they also exacerbate the heating problem described above.

Summary of the Invention

Accordingly, the present invention includes a liquid crystal display projection system having a display panel which is more easily cooled, which has improved illumination, and which accepts a wider angle of light than presently available systems. The system includes a projection panel having an LCD with dichroic polarizers provided on both sides thereof. A reflective prepolarizer is provided adjacent one of the dichroic polarizers. Light rays are directed through the reflective prepolarizer and on through the LCD and dichroic polarizers. In one embodiment, a quarter-wave plate is provided between the light source and reflective prepolarizer, and a reflector is provided behind the light source.

The reflective prepolarizer is preferably a multilayer optical polymeric film having several pairs of alternating layers. Each of the layer pairs exhibits a refractive index difference between the adjacent layers in a first direction in the plane of the reflective polarizer and exhibits essentially no refractive index difference between adjacent layers in a second direction in the plane of the reflective polarizer and orthogonal to the first direction. One such film has a plurality of alternating layers of semi-crystalline naphthalene dicarboxylic acid polyesters and another polymer. The dichroic polarizers are preferably secured to the display. The reflective prepolarizer is

preferably secured to one of the dichroic polarizers. A condensing lens, such as a fresnel lens, may be provided between the reflective prepolarizer and the light source.

Another embodiment of the present invention includes an LCD projection system including a projection panel, light source, and reflector. The projection panel includes an LCD having a polarizer, such as a dichroic polarizer on one side and a reflective polarizer on the side facing the light source. A quarter-wave plate is secured to the reflective polarizer, which is similar to the reflective prepolarizer described above.

The present invention also includes an LCD panel including an LCD having a polarizer on one side and a reflective polarizer on the other, and having a quarter-wave plate secured to the reflective polarizer.

The invention is also directed toward an overhead projector including a projection lamp, a fresnel lens, a quarter-wave plate secured to the fresnel lens, and a reflecting polarizer (as described above) secured to the quarter-wave plate. This allows one to receive the benefits of the invention while using a standard LCD panel for projection.

In another embodiment, the invention is directed to an LCD projection system including an overhead projector, an adapter panel placed on the projector, and an LCD panel placed on the adapter panel. The adapter panel includes a quarter-wave plate and the reflecting polarizer described above. The adapter panel allows one to receive the benefits of the invention while using a standard projector and a standard LCD panel.

Brief Description of the Drawing

FIGURE 1 is a schematic side view according to one embodiment of the present invention.

FIGURE 2 is a schematic side view according to another embodiment of the present invention.

FIGURES 3-4 are schematic side views according to further embodiments of the present invention.

FIGURE 5 is a schematic side view demonstrating how the brightness of a display according to the invention was measured.

FIGURE 6 is a graph generated by optical modeling showing the wide range of angular acceptance of the system shown in FIGURE 5 according to the present invention.

FIGURE 7 is a schematic perspective view of the reflecting polarizer for use with the present invention.

FIGURE 8 shows the optical performance of the reflecting polarizer described in Example 1.

FIGURES 9 and 10 show the optical performance of the reflecting polarizers described in Examples 3 and 4, respectively.

Detailed Description

A liquid crystal display projection system according to the present invention is shown in FIGURE 1. System 10 comprises a panel 12, converging lens 14, light source 16, optional reflector 18, optional mirror 30, and projection lens 32. Panel 12 comprises liquid crystal display (LCD) 20, first dichroic polarizer 22, second dichroic polarizer 24, reflecting prepolarizer 26, and optional quarter-wave plate 28. Dichroic polarizers 22 and 24 are provided on opposite sides of LCD 20. Prepolarizer 26 is positioned between first dichroic polarizer 22 and light source 16, and optional quarter-wave plate 28 is positioned between reflecting prepolarizer 26 and the light source. Let a be the polarization state that is passed by first dichroic polarizer 22. Reflecting prepolarizer 26 is also aligned so that it also passes a -polarized light.

Divergent light rays emitted from light source 16 are converged by converging lens 14. Light rays having a polarization a pass through reflecting prepolarizer 26 and first dichroic polarizer 22 and are then modulated, i.e., changed in phase, by the pixels in LCD 20, and then transmitted by the second dichroic polarizer 24 to the degree enabled by the phase change in the LCD. The light rays are then reflected by mirror 30 through projection lens 32 toward a viewing screen (not shown). Light rays having a polarization b perpendicular to polarization a are partially reflected by reflecting prepolarizer 26.

If reflecting prepolarizer 26 were an "ideal" polarizer, it would reflect 100% of light rays having b polarization, and would thus obviate the need for first polarizer 22.

However, reflecting prepolarizer 26 is usually less than ideal--the polarization efficiency of prepolarizer 26 may be, for example, about 80%. Even if reflecting prepolarizer 26 is less than ideal, to the extent that the polarization efficiency is greater than zero, it contributes to reducing heat buildup within panel 12 by reducing the amount of light absorbed by first polarizer 22 (by reflecting some of the b polarized light before it reaches the first polarizer).

The arrangement above is advantageous in that the amount of heat absorbed by first polarizer 22 and, thus, panel 12, is reduced. This is true even though the light rays passing through reflecting prepolarizer 26 are not parallel to each other, but rather are converging. Thus, only one converging lens element is needed. In an alternative embodiment, a second reflecting polarizer (not shown) may be provided between dichroic polarizer 24 and LCD 20.

However, as described above, light rays reflected by reflecting prepolarizer 26 may be wasted. These light rays may be "recycled" by placing a one-quarter wavelength ($\frac{1}{4}\lambda$) plate 28 adjacent the side of reflecting prepolarizer 26 opposite LCD 20, with the optical axes of $\frac{1}{4}\lambda$ plate 28 oriented at a 45° angle to the optical axes of prepolarizer 26 and by providing reflector 18 on the side of light source 16 opposite the panel. In this case, b-polarized light reflected by reflecting prepolarizer 26 becomes circularly polarized light of a certain handedness (right or left) after traversing $\frac{1}{4}\lambda$ plate 28. When this circularly polarized light is reflected by reflector 18, it changes to circularly polarized light of the opposite handedness. When it again traverses $\frac{1}{4}\lambda$ plate 28 in the forward direction, it becomes a-polarized linear light, and thus passes through reflecting prepolarizer 26 and first dichroic polarizer 22 to contribute to increased luminance of system 10.

Another embodiment of a liquid crystal display projection system according to the present invention is shown in FIGURE 2. System 50 comprises a panel 52, converging lens 54, light source 56, optional reflector 58, optional mirror 70, and projection lens 72. Panel 52 comprises LCD 60, dichroic polarizer 64, reflecting polarizer 62, and optional quarter-wave plate 66. Dichroic polarizer 64 and reflecting polarizer 62 are provided on opposite sides of LCD 60. Quarter-wave plate 66 is

positioned between reflecting polarizer 62 and light source 56, with the optical axes of $\frac{1}{4}\lambda$ plate 66 oriented at a 45° angle to the optical axes of reflecting polarizer 62.

Divergent light rays emitted from light source 56 are converged by converging lens 54. Light rays having a polarization a pass through quarter-wave plate 66 and reflecting polarizer 62, and are then modulated, i.e., changed in phase, by the pixels in LCD 60, and then transmitted by dichroic polarizer 64 to the degree enabled by the phase change in the LCD. Those light rays are then reflected by mirror 70 through projection lens 72 toward a viewing screen (not shown).

Light rays having a polarization b perpendicular to polarization a are reflected by reflecting polarizer 62, and become light rays of a certain handedness (right or left) after traversing $\frac{1}{4}\lambda$ plate 66. As explained above, when this circularly polarized light is reflected by reflector 58, it changes to circularly polarized light of the opposite handedness. When it again traverses $\frac{1}{4}\lambda$ plate 66 in the forward direction, it becomes a-polarized linear light, and thus passes through reflecting polarizer 62 to contribute to the increased illumination of system 50.

In an alternative embodiment, a second reflecting polarizer (not shown) may be provided between dichroic polarizer 64 and LCD 60. In another embodiment, dichroic polarizer 64 may be replaced by a reflecting polarizer.

A third embodiment of the present invention is shown as projection system 120 in FIGURE 3. System 120 is comprised of LCD panel 130 (which includes dichroic polarizers on each side of an LCD) and overhead projector 132. Projector 132 includes projection lamp 122, reflector 132, converging lens 124, quarter-wave plate 126, and reflecting polarizer 128, as shown in FIGURE 3. Reflecting polarizer 128 and LCD panel 130 should be oriented so that the polarization axes of the reflecting polarizer and the dichroic polarizer in the LCD panel facing the reflecting polarizer are parallel. Reflecting polarizer 128 and quarter-wave plate 126 should be oriented so that their polarization axes differ by 45° .

System 120 is advantageous in that it allows for a standard LCD panel to be used with a projector made according to the present invention. And when a conventional transparency (instead of an LCD panel) is placed on the projector

stage, the projector provides increased light transmission over projectors which have built-in dichroic polarizers.

A fourth embodiment of the present invention is shown as projection system 140 in FIGURE 4. System 140 is comprised of overhead projector 142, adapter panel 150, and LCD panel 148 (which includes dichroic polarizers on each side of an LCD). Adapter panel 150 is comprised of quarter-wave plate 144 and reflecting polarizer 146, as shown in FIGURE 4, whose optical axes are at 45° with respect to each other. Reflecting polarizer 146, LCD panel 148, and quarter-wave plate 144 should be oriented in the manner discussed above for system 120. System 140 is advantageous in that it allows a standard LCD panel to be used with a standard projector due to the use of the adapter panel according to the present invention.

The LCDs in the above embodiments may be any type of polarization-dependent liquid crystal display, which may include two rigid or flexible substrates, such as plastic or glass. Polarizers 22, 24, and 64, as well as the polarizers included within LCD panels 130 and 148, are preferably absorbing dye-type dichroic polarizers and should be oriented with respect to each other so that liquid crystal display 20 or 60 operates in the desired mode (normally white or normally black). Converging lenses 14, 54, and 124 are preferably fresnel lenses comprising optical plastic such as cellulose acetate butyrate, polycarbonate, or acrylic. Overhead projector 142 preferably incorporates such a converging lens.

Light sources 16, 56, and 122, as well as the light source used in overhead projector 142, may be those typically used, such as incandescent or gas-discharge sources. Reflectors 18 and 58 and mirrors 30 and 70 are those typically used, such as metals or multilayer dielectrics. Reflectors 18 and 58 may be spherical or elliptical. Projection lenses 32 and 72 and quarter-wave plates 28, 66, 126, and 144 are also standard.

FIGURE 7 is a schematic perspective diagram of a segment of a preferred reflective polarizer 36 for use as a reflective polarizer in the present invention. FIGURE 7 includes a coordinate system 38 that defines x, y and z directions. Reflective polarizer 36 is a multilayered stack of alternating layers of two different materials. The two materials are referred to as material "A" and material "B" in the

drawing and description. Adjacent layers 41 and 43 of material A and material B comprise an exemplary layer pair 44. Layer pair 44 exhibits a refractive index difference between adjacent layers 41 and 43 associated with the x direction, and essentially no refractive index difference between layers 41 and 43 associated with the y direction.

In a preferred embodiment of the device of this invention, the reflective polarizers each comprise a multilayered sheet of alternating layers of materials A and B in which each of the layers has an average thickness of less than 0.5 μm . A layer of material A adjacent to a layer of material B comprises a layer pair. The number of layer pairs is preferably in the range from about 10 to 2000, and more preferably about 200 to 1000.

The multilayered sheet is formed by coextrusion of materials A and B into a sheet, followed by uniaxial stretching in the x direction. The stretch ratio is defined as the dimension after stretch divided by the dimension before stretch. The stretch ratio is preferably in the range from 2:1 to 10:1, more preferably 3:1 to 8:1, and most preferably 4:1 to 7:1, e.g., 6:1. The sheet is not appreciably stretched in the y direction. Material A is a polymeric material chosen to exhibit a stress-induced birefringence, or change in index of refraction with stretching. For example, a uniaxially stretched sheet of material A will have one index of refraction, n_{Ax} , associated with the stretch direction ($n_{Ax}=1.88$, for example) and a different index of refraction, n_{Ay} , associated with the transverse direction ($n_{Ay}=1.64$, for example). Material A exhibits a difference in index of refraction between the stretch and transverse directions ($n_{Ax}-n_{Ay}$) of at least 0.05, preferably at least 0.10, and more preferably at least 0.20. Material B is a material chosen such that its refractive index, n_{By} , is substantially equal to n_{Ay} after the multilayer film is stretched. Upon stretching, the value of n_{Bx} preferably decreases.

After stretching, the multilayered sheet of this embodiment shows a large difference in index of refraction between adjacent layers associated with the stretch direction (defined as $\Delta n_x = n_{Ax} - n_{Bx}$). In the transverse direction, however, the index of refraction difference between adjacent layers is substantially zero (defined as $\Delta n_y = n_{Ay} - n_{By}$). These optical characteristics cause the multilayered stack to act

as a reflective polarizer that will transmit the polarization component of randomly polarized light that is parallel to transmission axis 40 shown in FIGURE 7. The portion of light which is transmitted by reflective polarizer 36 is referred to as having polarization state a. The portion of light which does not pass through reflective polarizer 36 has polarization state b which corresponds to extinction axis 42 shown in FIGURE 7. Extinction axis 42 is parallel to the stretch direction x. Therefore, b-polarized light encounters the index of refraction difference, Δn_x , which results in its reflection. The reflective polarizer is preferably at least 50% reflective of b-polarized light and more preferably at least 90%. The third refractive index differential, Δn_z , is important for controlling the off-axis reflectivity of the reflective polarizer. For high extinction ratios of the b-polarized light and high transmission of the a-polarized light, at large angles of incidence, it is preferred that $\Delta n_z = n_{Az} - n_{Bz} < 0.5 \Delta n_x$, more preferably less than $0.2 \Delta n_x$, and most preferably less than $0.01 \Delta n_x$.

The optical behavior and design of such reflective polarizers is described in more detail in Assignee's copending application, U.S. Serial No 08/402041, filed March 10, 1995, entitled "Optical Film."

One of ordinary skill will be able to select materials appropriate to achieve the desired refractive index relationships. In general, Material A may be selected from a semi-crystalline polymeric material, such as a semi-crystalline naphthalene dicarboxylic acid polyester or polyethylene naphthalate (PEN) and isomers thereof (e.g., 2,6-, 1,4-, 1,5-, 2,7-, and 2,3-PEN). Material A may also be selected from other semi-crystalline polymer materials, such as polyethylene terephthalate (PET), polyethylene isophthalate (PEI), and copolymers of PEN, PET, and PEI. As used herein, coPEN includes copolymers of PEN and coPET includes copolymers of PET. Material B may be a semi-crystalline or amorphous polymeric material, such as syndiotactic polystyrene (sPS), and copolymers, e.g., coPEN, coPET, and copolymers of Eastar, which is polycyclohexanedimethylene terephthalate commercially available from Eastman Chemical Co. The coPEN described may also be a blend of pellets where at least one component is a polymer based on naphthalene dicarboxylic acid, and other components are other polyesters or

polycarbonates, such as a PET, a PEN or a co-PEN. Materials A and B are preferably chosen to have similar rheological properties (e.g., melt viscosities) such that they can be coextruded.

5 The reflective polarizer is prepared by coextruding material A and material B to form a multilayered film and then orienting the film by stretching substantially in one direction (uniaxially) at a selected temperature, optionally followed by heat-setting at a selected temperature. The film may be allowed to dimensionally relax in the cross-stretch direction (orthogonal to the stretch direction) in the range from the natural reduction in cross-stretch dimension (equal to the square root of the stretch ratio) to no reduction in cross-stretch dimension (corresponding to complete
10 constraint). The film may be stretched in the machine direction, as with a length orienter, or in the width direction, as with a tenter.

 It will be apparent to one of ordinary skill to select a combination of process variables such as stretch temperature, stretch ratio, heat set temperature and cross-stretch relaxation, to yield a reflective polarizer having the desired refractive index
15 relationship.

 In a particularly preferred embodiment, the multilayered sheet comprises a stack of layer pairs of materials A and B as described above, in which the stack is divided into one or more segments of layer pairs. Each segment is designed to have maximum reflectivity of light having a given bandwidth by having layer pairs which
20 each have a combined thickness of about one half of the wavelength in the center of the bandwidth for that segment. The combination of segments having different layer pair thicknesses allows the reflective polarizer to reflect light having a relatively large bandwidth.

25 For example, the multilayered sheet may include ten segments having layer pairs with a combined thickness ranging from 100 nm to 200 nm. Each segment may include between 10 and 50 layer pairs. This polarizer is capable of reflecting light having wavelengths in the range from 400 to 800 nm. Alternatively, the thicknesses of the layered pairs may be continuously graded from 100 to 200 nm.

30 The invention will now be described with reference to the following non-limiting examples. All measurements are approximate.

Example 1

The luminance gain obtained by the recycling feature of the present invention was measured by constructing a system 100, illustrated schematically in
5 FIGURE 5. System 100 was comprised of a projector 102, a quarter-wave plate 104 provided on the projector stage, a reflecting polarizer 106, and a dichroic polarizer 108, as shown in FIGURE 5.

Quarter-wave plate 104 was a 30 by 30 cm 140 nm-thick retardation film (i.e., for quarter-wave at 560 nm) from Polaroid Corporation, Norwood,
10 Massachusetts, U.S.A. Dichroic polarizer 108 was a 30 by 30 cm HN42 polarizer from Polaroid Corporation, Projector 102 was a standard transmissive overhead projector from 3M Company, St. Paul, Minnesota (3M model 2150).

Reflecting polarizer 106 contained 601 layers and was produced by extruding the web and by orienting the film two days later on a tenter. Polyethylene
15 naphthalate (PEN) with an intrinsic viscosity of 0.5 dl/g (60 wt. % phenol/40 wt. % dichlorobenzene) was delivered by one extruder at a rate of 34 kg per hour and CoPEN (70 mole %, 2,6 NDC (naphthalene dicarboxylic acid), and 30 mole % DMT (dimethyl terephthalate)) with an intrinsic viscosity of 0.55 dl/g (60 wt. % phenol/40 wt. % dichlorobenzene) was delivered by another extruder at a rate of 30
20 kg per hour. PEN was on the skin layers, which are coextruded as thick outer layers through the same feedblock and are folded in as both internal and external layers by the multipliers. Internal and external skins comprised 8% of the total thickness of the polarizer. The feedblock method was used to generate 151 layers which was passed through two multipliers producing an extrudate of 601 layers.
25 U.S. Patent No. 3,565,985 describes similar coextrusion multipliers. All stretching was done in the tenter. The film was preheated to about 140°C in about 20 seconds and drawn in the transverse direction to a draw ratio of about 4.4 at a rate of about 6% per second. The film was then relaxed about 2% of its maximum width in a heat-set oven set at 240°C. The finished film thickness was 46 µm.

30 The transmission of the film is shown in FIGURE 8. Curve a shows transmission of a-polarized light at normal incidence, curve b shows transmission of

a-polarized light at 60° incidence, and curve c shows transmission of b-polarized light at normal incidence. Note the nonuniform transmission of a-polarized light at both normal and 60° incidence. Also note the nonuniform extinction of b-polarized light in the visible range (400-700 nm) shown by curve c.

5 Dichroic polarizer 108 and reflecting polarizer 106 were oriented so that their polarization axes were parallel and were placed atop quarter-wave plate 104, whose optical axes are at 45° to those of the polarizers. Light projected to the screen (optics and screen are not shown) was measured with a photometer.

10 The screen intensity for the case when the quarter-wave plate 104 was in the position described above was measured to be 15% higher than for the case when the $\lambda/4$ plate 104 was removed from system 100. In other words, insertion of the $\lambda/4$ plate in conjunction with the reflecting polarizer allows for use of 15% of the polarized light that would otherwise be lost without the use of the reflecting polarizer. This compares favorably with the 7% increase reported for systems using
15 a microstructured MacNeille polarizer as the reflecting polarizer. See European Patent Application No. 0 573 905 A1, column 11, by Michael F. Weber, published December 15, 1993, assigned to 3M Company. It is expected that a more sophisticated illumination system might increase this 15% recycling rate. Similarly, reflecting polarizers having improved performance such as those in Examples 3 and
20 4 would increase the recycling rate.

Example 2

25 The arrangement shown in FIGURE 5 was optically modeled to demonstrate angular dependence on incident light for two different reflective polarizers: a multilayer optical film and a microstructure MacNeille polarizer.

30 The results of the optical modeling are shown as graph 160 in FIGURE 6. The transmission of the desired polarization by the multilayer optical film was greater than 90% over a broad angular range of incident light from -45° to +45°. (See line 162 in FIGURE 6.) In contrast, the transmission of the desired polarization by the MacNeille polarizer fell below 90% outside the narrow angular range from -5° to +5°. (See line 164 in FIGURE 6.)

Example 3

Another reflective polarizer for use in the present invention was constructed.

The reflecting polarizer contained 603 layers and was made on a sequential, flat
5 film-making line via a coextrusion process. Polyethylene naphthalate (PEN) with an
intrinsic viscosity of 0.47 dl/g (in 60 wt% phenol plus 40 wt% dichlorobenzene)
was delivered by an extruder at a rate of 38 kg per hour and CoPEN was delivered
by another extruder at 34 kg per hour. The CoPEN was a copolymer of 70 mole
10 %, 2,6 naphthalene dicarboxylate methyl ester, 15 mole % DMT, and 15 mole %
dimethyl isophthalate with ethylene glycol. The feedblock method was used to
generate 151 layers. The feedblock was designed to produce a gradient distribution
of layers with a ratio of thicknesses of the optical layers of 1.22 for the PEN and
1.22 for the CoPEN. This optical stack was multiplied by two sequential
15 multipliers. The nominal multiplication ratio of the multipliers was 1.2 and 1.4,
respectively. Between the final multiplier and the die, skin layers were added
composed of the same CoPEN described above, delivered by a third extruder at a
total rate of 48 kg per hour. The film was subsequently preheated to 150°C in
about 30 seconds, and drawn in the transverse direction to a draw ratio of
approximately 6 at an initial rate of about 20% per second. The finished film
20 thickness was approximately 89 μm .

FIGURE 9 shows the optical performance of this reflecting polarizer.
Curve a shows transmission of light polarized in the non-stretch direction at normal
incidence, curve b shows transmission of light having both plane of incidence and
plane of polarization parallel to the non-stretch direction at a 50° angle of incidence,
25 and curve c shows transmission of light polarized in the stretch direction at normal
incidence. Note the very high transmission of light polarized in the non-stretch
direction. Average transmission for curve a over 400-700 nm is 87%. Also note
the very high extinction of light polarized in the stretched direction in the visible
range (400-700 nm) shown by curve c. The film has an average transmission of
30 2.5% for curve c between 400 and 700 nm. The % RMS color for curve b is 5%.

The % RMS color is the root mean square of the transmissivity over the wavelength range of interest.

Example 4

5 Yet another reflecting polarizer for use in the present invention was constructed. The reflecting polarizer comprised a coextruded film containing 481 layers made by extruding the cast web in one operation and later orienting the film in a laboratory film-stretching apparatus. The feedblock method was used with a 61 layer feedblock and three (2x) multipliers. Thick skin layers were added between
10 the final multiplier and the die. Polyethylene naphthlate (PEN) with an intrinsic viscosity of 0.47 dl/g (60 wt. % phenol/40 wt. % dichlorobenzene) was delivered to the feedblock by one extruder at a rate of 11.4 kg per hour. Glycol modified polyethylene cyclohexane dimethane terephthalate (PCTG 5445 from Eastman) was delivered by another extruder at a rate of 11.4 kg per hour. Another stream of PEN
15 from the above extruder was added as skin layers at a rate of 11.4 kg. The cast web was 0.2 mm thick and 30 cm wide. The web was uniaxially oriented using a laboratory stretching device that uses a pantograph to grip a section of film and stretch it in one direction at a uniform rate while it is allowed to freely relax in the other direction. The sample of web loaded was about 5.40 cm wide (the
20 unconstrained direction) and 7.45 cm long between the grippers of the pantograph. The web was loaded into the stretcher at about 100°C and heated to 135°C for 45 seconds. Stretching was then commenced at 20% per second (based on original dimensions) until the sample was stretched to about 6:1 (based on gripper-to-gripper measurements). Immediately after stretching, the sample was cooled by
25 blowing room temperature air at it. In the center, the sample was found to relax by a factor of 2.0.

FIGURE 10 shows the transmission of this multilayer film where curve a shows transmission of light polarized in the non-stretch direction at normal incidence, curve b shows transmission of light having both plane of incidence and
30 plane of polarization parallel to the non-stretched direction at a 60° angle of incidence (p-polarized light), and curve c shows the transmission of light polarized

in the stretch direction at normal incidence. Average transmission for curve a from 400-700 nm is 89.7%, average transmission for curve b from 400-700 nm is 96.9%, and average transmission for curve c from 400-700 nm is 4.0%. % RMS color for curve a is 1.05%, and % RMS color for curve b is 1.44%.

- 5 Although the present invention has been described with reference to an LCD panel provided between the projector and screen, those skilled in the art will appreciate that the present invention also includes the use of additional LCD panels, such as a total of three to achieve full color.

We claim:

1. A liquid crystal display projection system (10), comprising:
a projection panel (12), comprising:
5 a liquid crystal display (20); and
a pair of dichroic polarizers (22, 24), wherein one polarizer is
provided adjacent each side of the display;
a light source (16) for directing light toward the panel; and
a reflective prepolarizer (26) comprising a multilayer optical film (36)
10 provided between the light source and the dichroic polarizer
facing the light source, the film comprising a multilayered stack
of pairs (44) of adjacent material layers, each of the layer pairs
exhibiting a refractive index difference between the adjacent
layers (41, 43) in a first direction in the plane of the reflective
15 prepolarizer and exhibiting essentially no refractive index
difference between adjacent layers in a second direction in the
plane of the reflective prepolarizer and orthogonal to the first
direction.
- 20 2. The system of claim 1, wherein the film comprises a plurality of
alternating layers of semi-crystalline naphthalene dicarboxylic acid polyesters and
another polymer.
- 25 3. The system of claim 1, further comprising:
a quarter-wave plate (28) provided between the light source and the
reflective prepolarizer; and
a reflector (18) provided on the side of the light source opposite the
panel.
- 30 4. The system of claim 1, further comprising a reflective polarizer provided
between the liquid crystal display and the dichroic polarizer on the side of the liquid

crystal display opposite the light source, the reflective polarizer comprising a multilayer optical film (36) comprising a multilayered stack of pairs (44) of adjacent material layers, each of the layer pairs exhibiting a refractive index difference between the adjacent layers (41, 43) in a first direction in the plane of the reflective polarizer and exhibiting essentially no refractive index difference between adjacent layers in a second direction in the plane of the reflective polarizer and orthogonal to the first direction.

5 5. A liquid crystal display projection system (50), comprising:
a projection panel (52), comprising:
10 a liquid crystal display (60);
a first polarizer (64) provided on one side of the display; and
a second polarizer (62), which is a reflective polarizer, provided
on the other side of the display, wherein the second
polarizer comprises a multilayer optical film (36)
15 comprising a multilayered stack of pairs (44) of adjacent
material layers, each of the layer pairs exhibiting a
refractive index difference between the adjacent layers
(41, 43) in a first direction in the plane of the reflective
polarizer and exhibiting essentially no refractive index
20 difference between adjacent layers in a second direction
in the plane of the reflective polarizer and orthogonal to
the first direction; and
a light source (56) for directing light toward the second polarizer.

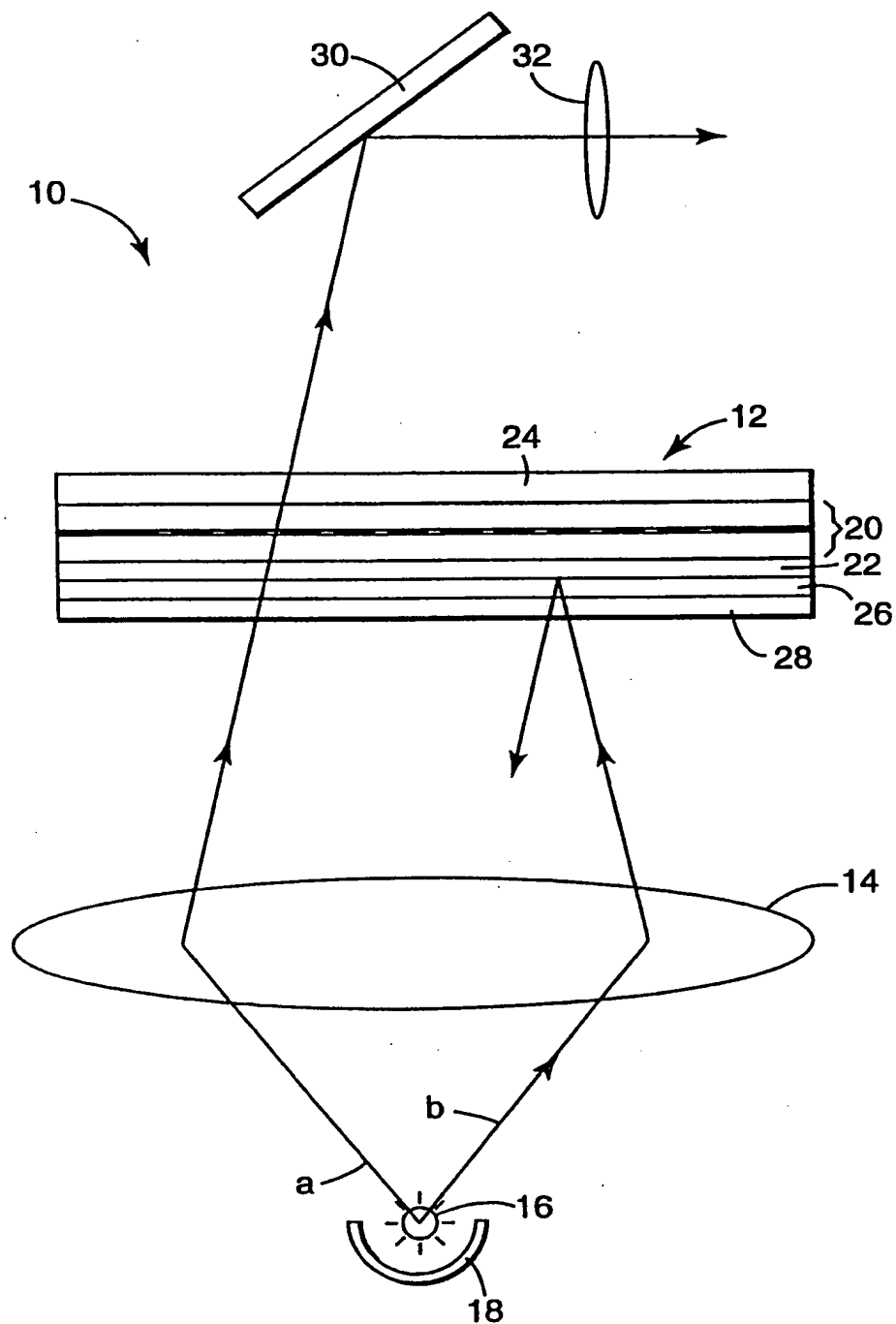
25 6. The system of claim 5, further comprising a third polarizer, which is a
reflective polarizer, provided between the first polarizer and the liquid crystal display,
the third polarizer comprising a multilayered stack of pairs (44) of adjacent material
layers, each of the layer pairs exhibiting a refractive index difference between the
adjacent layers (41, 43) in a first direction in the plane of the third polarizer and
30 exhibiting essentially no refractive index difference between adjacent layers in a second
direction in the plane of the third polarizer and orthogonal to the first direction.

7. The system of claim 5, wherein the first polarizer is a reflective polarizer comprising a multilayered stack of pairs (44) of adjacent material layers, each of the layer pairs exhibiting a refractive index difference between the adjacent layers (41, 43) in a first direction in the plane of the first polarizer and exhibiting essentially no refractive index difference between adjacent layers in a second direction in the plane of the first polarizer and orthogonal to the first direction.
8. The system of claim 7, further comprising:
a quarter-wave plate (66) provided between the light source and the second polarizer; and
a reflector (58) provided on the side of the light source opposite the panel.
9. A liquid crystal panel, comprising:
a liquid crystal display (60);
a first polarizer (64) secured to one side of the display;
a second polarizer (62), which is a reflective polarizer, secured to the other side of the display, wherein the second polarizer comprises a multilayer optical film (36) comprising a multilayered stack of pairs (44) of adjacent material layers, each of the layer pairs exhibiting a refractive index difference between the adjacent layers (41, 43) in a first direction in the plane of the reflective polarizer and exhibiting essentially no refractive index difference between adjacent layers in a second direction in the plane of the reflective polarizer and orthogonal to the first direction; and
a quarter-wave plate (66) secured to the second polarizer.
10. An overhead projector (132), comprising, in order:
a projection lamp (122);
a converging lens (124);

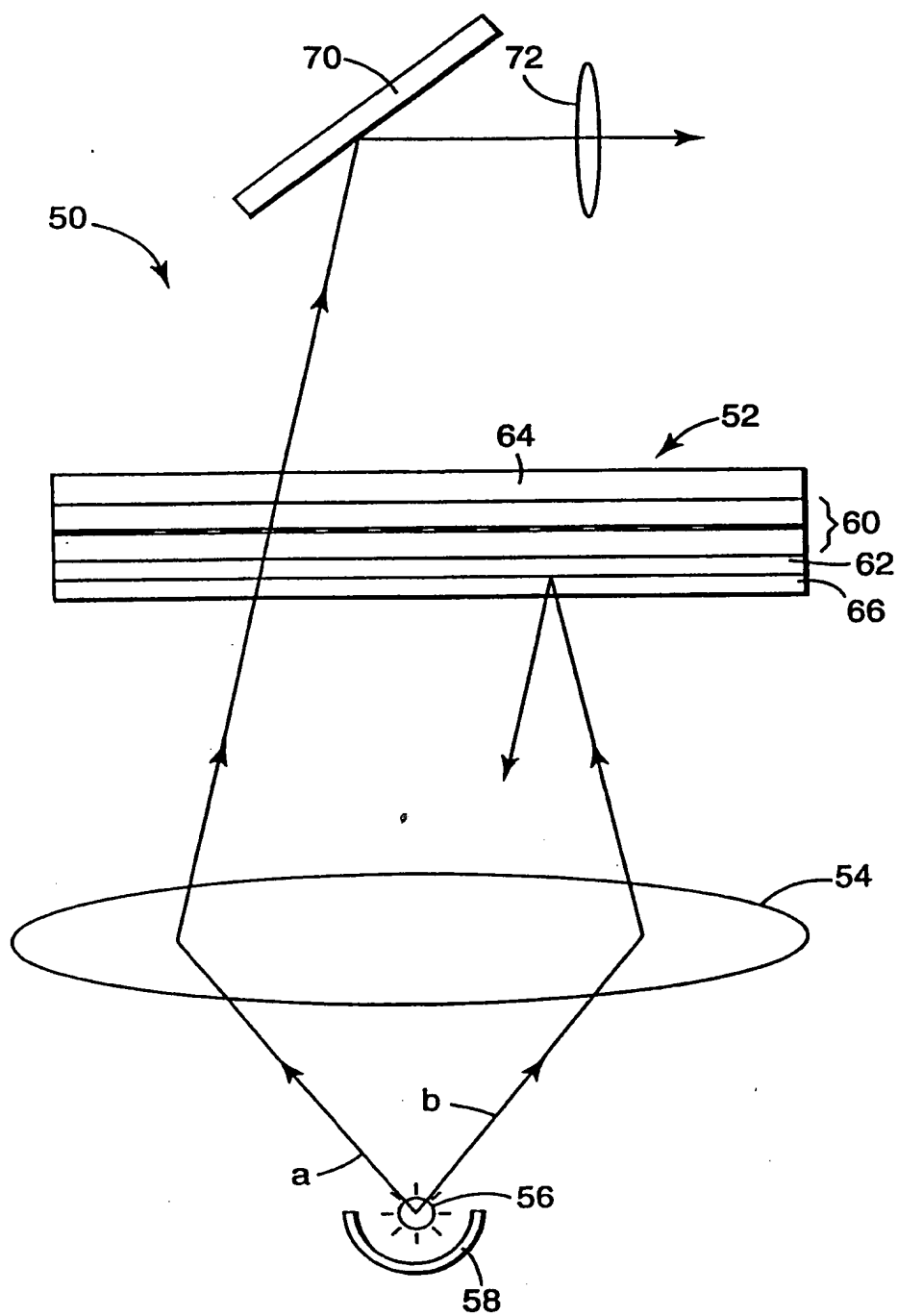
a quarter-wave plate (126) secured to the converging lens; and
a reflecting polarizer (128) secured to the quarter-wave plate, the
reflecting polarizer comprising a multilayer optical film (36)
comprising a multilayered stack of pairs (44) of adjacent
material layers, each of the layer pairs exhibiting a refractive
index difference between the adjacent layers (41, 43) in a first
direction in the plane of the reflective polarizer and exhibiting
essentially no refractive index difference between adjacent layers
in a second direction in the plane of the reflective polarizer and
orthogonal to the first direction.

11. A liquid crystal display projection system (140), comprising in order:
an overhead projector (142);
an adapter panel (150) provided on the projector, the adapter panel
comprising a quarter-wave plate (144) and a reflecting polarizer
(146), the reflecting polarizer comprising a multilayer optical
film (36) comprising a multilayered stack of pairs (44) of
adjacent material layers, each of the layer pairs exhibiting a
refractive index difference between the adjacent layers (41, 43)
in a first direction in the plane of the reflective polarizer and
exhibiting essentially no refractive index difference between
adjacent layers in a second direction in the plane of the reflective
polarizer and orthogonal to the first direction; and
a liquid crystal display projection panel (148) provided on the adapter
panel, the projection panel comprising a liquid crystal display
and a pair of dichroic polarizers provided on opposite sides of
the display.

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**Fig. 1**

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**Fig.2**

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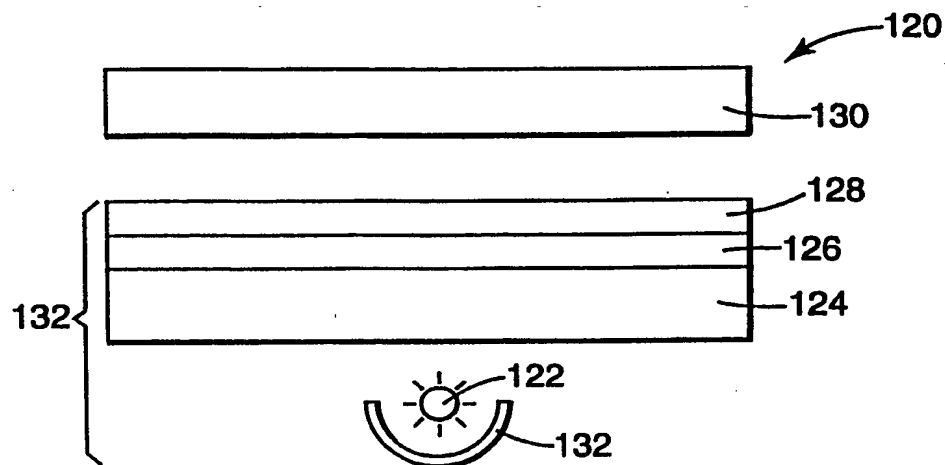


Fig. 3

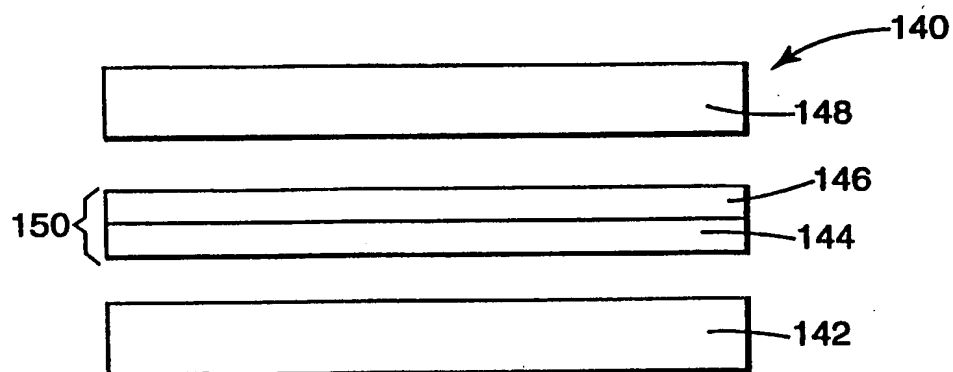


Fig. 4

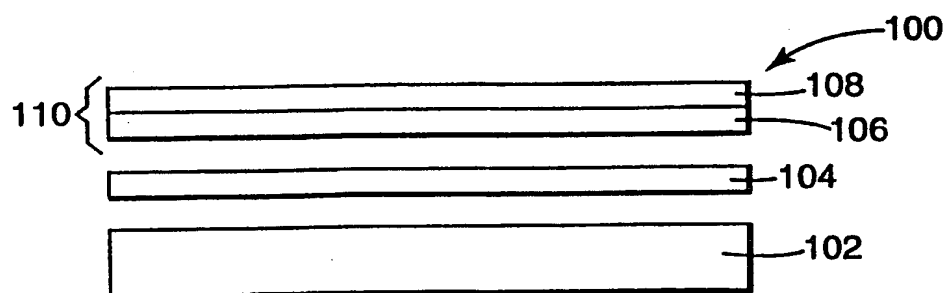
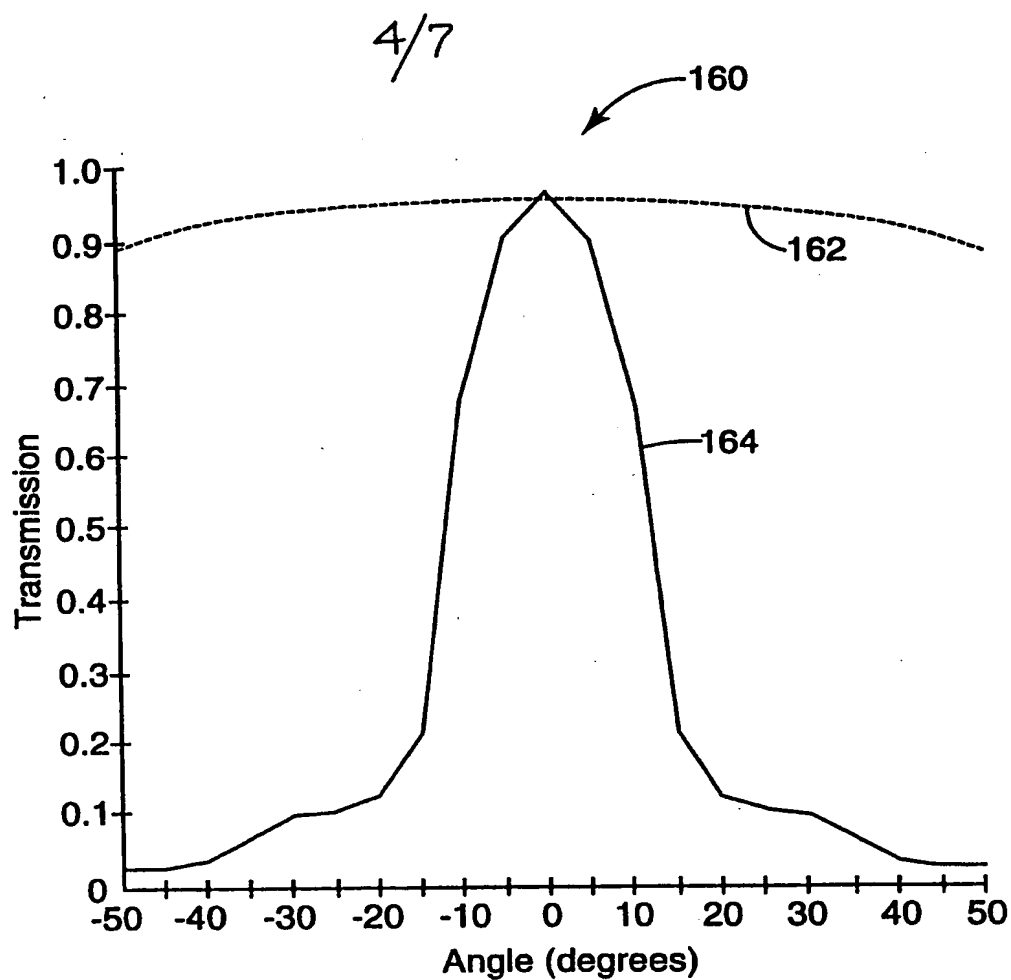
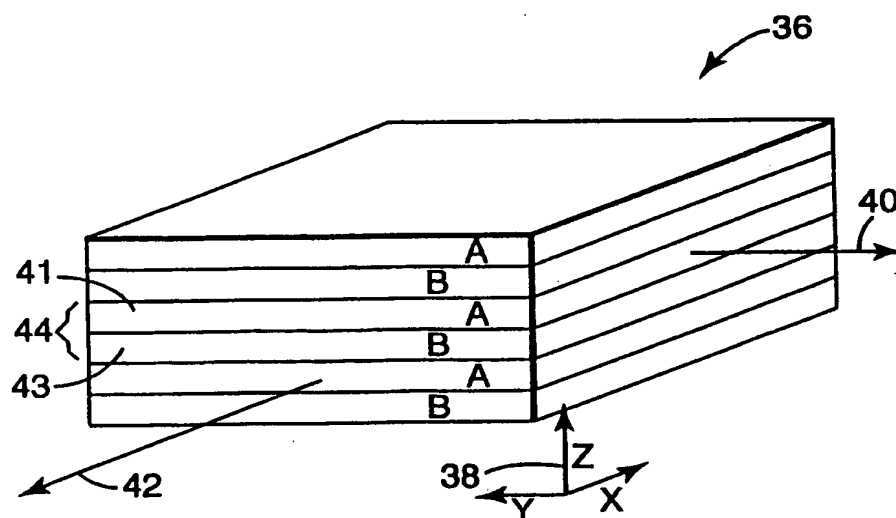
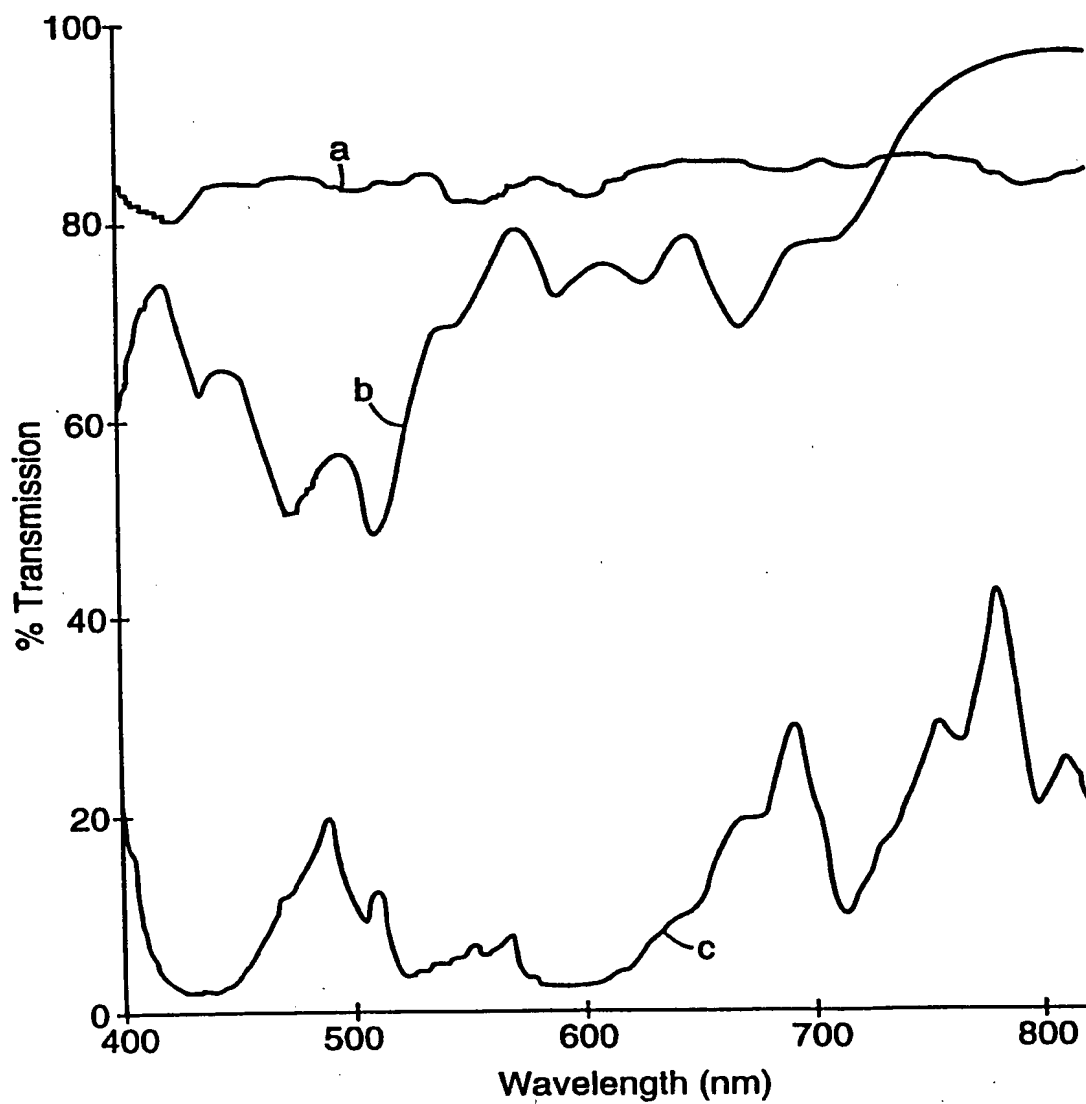


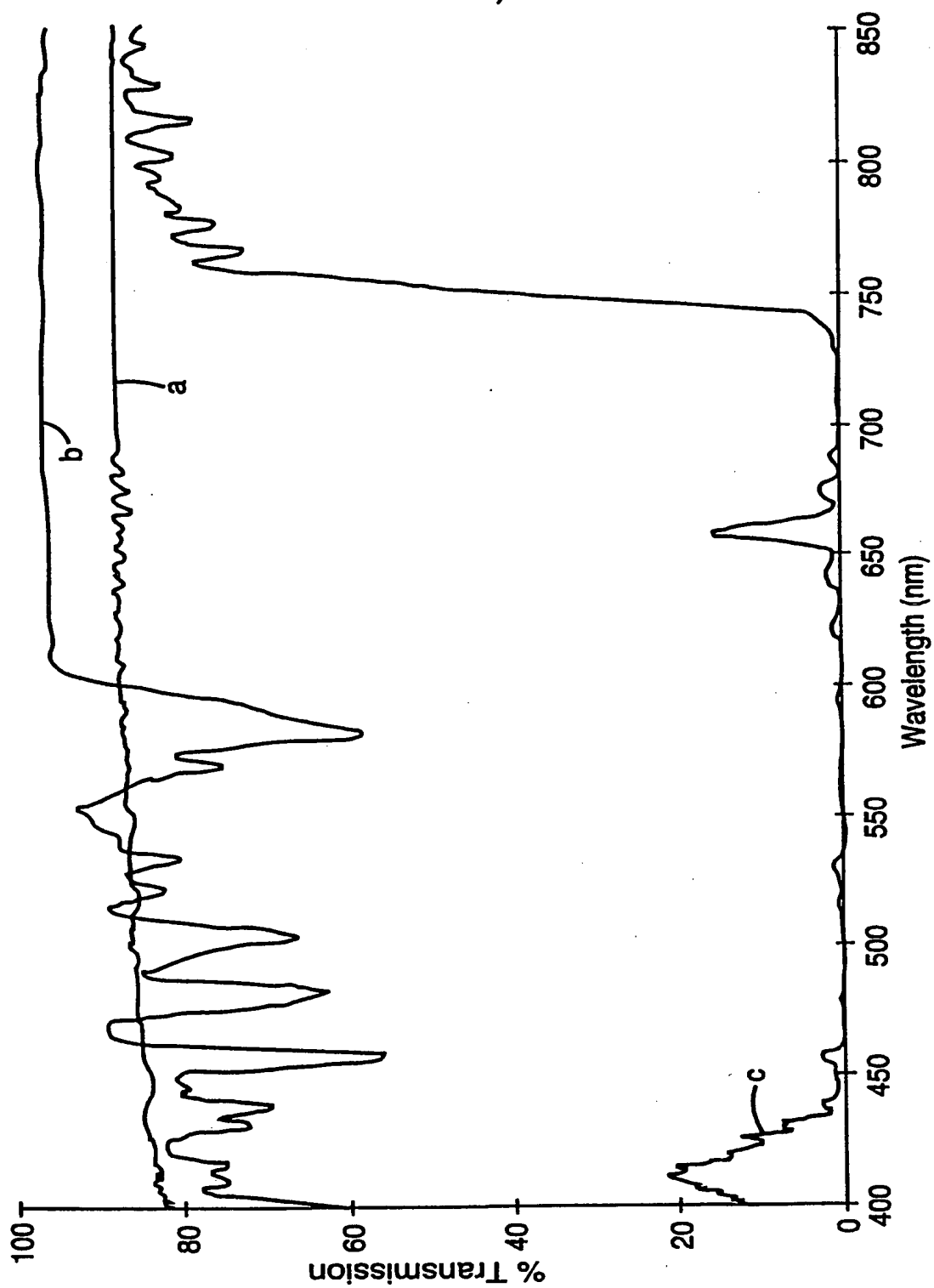
Fig. 5

**Fig. 6****Fig. 7**

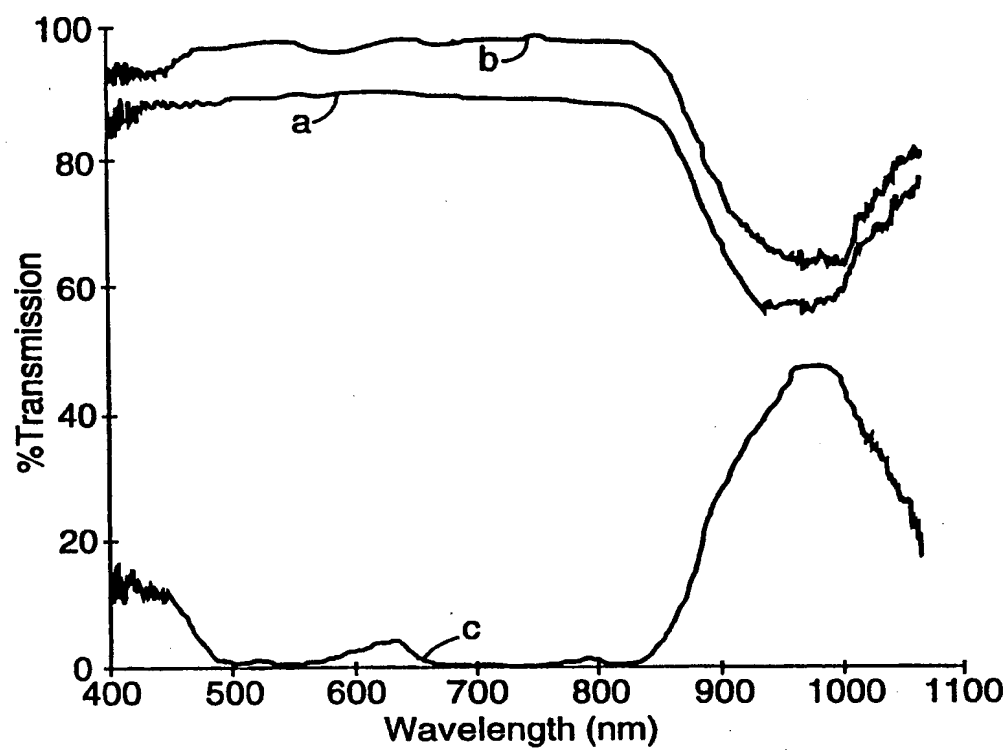
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**Fig. 8**

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**Fig. 9**

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**Fig. 10**

INTERNATIONAL SEARCH REPORT

International Application No
PCT/US 96/07080

A. CLASSIFICATION OF SUBJECT MATTER
IPC 6 G02B5/30 G02F1/1335

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
IPC 6 G02B G02F

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	WO,A,94 11776 (HONEYWELL INC.) 26 May 1994 see page 27, line 25 - page 28, line 7; figures 1,10	1-11
Y	US,A,3 610 729 (POLAROID CORP.) 5 October 1971 see the whole document	1-11
P,X	WO,A,95 17692 (3M CO.) 29 June 1995 see the whole document	1-11
A	EP,A,0 404 463 (DOW CHEMICAL CO.) 27 December 1990 see the whole document	1-11

☐ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

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Date of the actual completion of the international search

20 November 1996

Date of mailing of the international search report

29. 11. 96

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INTERNATIONAL SEARCH REPORT

Information on patent family members

International Application No

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